

# Work Order ID 70104

Thursday, May 26, 2011 3:59:37 PM



Page 1

Item ID: D205-633-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 5/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: 11-05-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9540	A
IIN-D205-633	B

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-013 CHG002/ DSI 9540

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

*ml 11 06 14 (2)*  
*for CL 11-6-14*

*11/6/10 sl (2)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70104**

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Item ID: D205-633-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step

Start Date: 5/26/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 5/26/2011 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00				<u>11</u>	<u>06</u>	<u>13</u>	<u>(2)</u>
130  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD205-633-013/ DSI 9540 Location: <u>70</u>	0.00  0.00							<u>Cup/14</u>
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>11/06/14</u> <u>MF</u> <u>11-06-14</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 70104

Parent Item: D205-633-013

Parent Item Name: Heli-Access-Step






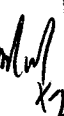








Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:F 02.07.11 Reformat; Removed D3010 ☐RF  
IPP rev G 07.08.22 Added hardware per DSI9302-013 EC IPP REV:H  
11.01.12 AS PER DSI 9540 REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D2022-101  X2 Spacer		Manufactured	No			110	Each	26.0000	 2	4			
				<u>Location</u>									
				ST504				26					
				67768				26					
 D2022-103  X2 Spacer		Manufactured	No			110	Each	9.0000	 2	4			
				<u>Location</u>									
				ST005				9					
				47964				9					
 D2562-013  X2 Strut		Manufactured	No			110	Each	4.0000	 1	2		11/6/10	2x
				<u>Location</u>									
				ST264				4					
				68707				4					
 D2563  X2 Step Weldment Assembly		Manufactured	No			110	Each	0.0000	 1	2		70105 11/6/14	2x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 70104

Parent Item: D205-633-013

Parent Item Name: Heli-Access-Step

Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00

D2565-201



Strut

Manufactured No

110 Each

8.0000



2

Location

Loc Qty

Loc Code

ST270

8

52387

8

Manufactured No

110 Each

1.0000



2

D2565-203



Strut

Location

Loc Qty

Loc Code

ST270

1

52388

1

Manufactured No

110 Each

7.0000



2

D2565-205



Strut

Location

Loc Qty

Loc Code

ST253

7

52389

7

Manufactured No

110 Each

4.0000



2

D2565-207



Strut

Location

Loc Qty

Loc Code

ST253

4

40009

4

Manufactured No

110 Each

3.0000



2

D2565-209



Strut

Location

Loc Qty

Loc Code

ST253

3

52391

3

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 70104

Parent Item: D205-633-013

Parent Item Name: Heli-Access-Step

Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00

D2565-211



Strut

Manufactured No

110 Each

9.0000



1

Location

Loc Qty

Loc Code

ST253

9

50061

4

67208

5

AN44-7A



Eyebolt

Purchased No

110 Each

26.0000



2

Location

Loc Qty

Loc Code

ST362

26

111177

6

112454

10

117764

10

AN4-5A



Bolt

Purchased No

110 Each

297.0000



2

Location

Loc Qty

Loc Code

ST355

200

117508

200

ST356

97

116191

47

116549

50

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 70104

Parent Item: D205-633-013

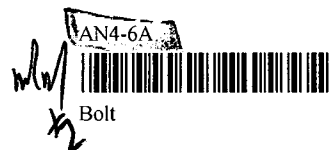
Parent Item Name: Heli-Access-Step

Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00



Purchased

No

110

Each

1,099.000



3 6  
sf

## Location

## Loc Qty

## Loc Code

ST356

899

115936

99

116400

400

116924

400

ST358

200

117514

200



Purchased

No

110

Each

269.0000



2 4  
sf

## Location

## Loc Qty

## Loc Code

ST356

269

115373

19

117443

50

117514

200



Purchased

No

110

Each

206.0000



1 2  
11/6/10 sl (2)

## Location

## Loc Qty

## Loc Code

ST357

104

116914

4

117619

100

ST358

102

117313

102

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 70104

Parent Item: D205-633-013

Parent Item Name: Heli-Access-Step

Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-10A  
Bolt

Purchased No

110 Each

192.0000

1 2

2

## Location

## Loc Qty

## Loc Code

ST356

192

116419

17

117313

50

117619

125

AN5-14A  
Bolt

Purchased No

110 Each

81.0000

1 2

2

## Location

## Loc Qty

## Loc Code

ST338

81

115374

81

AN960JD416  
Washer

NAS1149D0463J

Purchased No

110 Each

0.0000

16 32

2

AN960JD516  
Washer

NAS1149D0563J

Purchased No

110 Each

0.0000

4 6

6

MS21042L4  
Nut

Purchased No

110 Each

4,569.000

8 16

11/6/10

## Location

## Loc Qty

## Loc Code

ST300

4569

116823

769

117441

3000

117601

800

10

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 26, 2011 3:59:47 PM

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Work Order ID: 70104

Parent Item: D205-633-013

Parent Item Name: Heli-Access-Step



Start Date: 5/26/2011

Required Date: 5/26/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

1,223.000



Nut



4  
11/6/10 SD 20

Location

Loc Qty

Loc Code

ST300

1223

116105

263

116548

260

117441

500

117591

100

117611

100

4  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LISTS

## 5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			<del>D205-633-013</del>	<del>Heli-Access-Step™, Extended High Gear (31")</del>
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	<del>(2)</del>	2	2	<del>D2022-101</del>	<del>SPACER</del>
2	<del>(2)</del>	2	2	<del>D2022-103</del>	<del>SPACER</del>
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	<del>(1)</del>			<del>D2562-013</del>	<del>STRUT</del>
1	<del>(1)</del>	1	1	<del>D2563</del>	<del>WELDMENT-ASSEMBLY</del>
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	<del>(1)</del>			<del>D2565-201</del>	<del>STRUT</del>
	<del>(1)</del>			<del>D2565-203</del>	<del>STRUT</del>
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	<del>(1)</del>			<del>D2565-207</del>	<del>STRUT</del>
	<del>(1)</del>			<del>D2565-209</del>	<del>STRUT</del>
	<del>(1)</del>			<del>D2565-211</del>	<del>STRUT</del>
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	<del>(1)</del>	1		<del>AN44-7A</del>	<del>EYEBOLT</del>
2	<del>(1)</del>	1	2	<del>AN4-5A</del>	<del>BOLT</del>
2	<del>(3)</del>	3	2	<del>AN4-6A</del>	<del>BOLT</del>
2	<del>(2)</del>	2	2	<del>AN4-7A</del>	<del>BOLT</del>
1	<del>(1)</del>	1	1	<del>AN4-14A</del>	<del>BOLT</del>
	<del>(1)</del>	1		<del>AN4-10A</del>	<del>BOLT</del>
1			1	AN5-6A	BOLT
1	<del>(1)</del>	1	1	<del>AN5-14A</del>	<del>BOLT</del>
15	<del>(16)</del>	16	15	<del>AN960JD416</del>	<del>WASHER</del>
4	<del>(4)</del>	4	4	<del>AN960JD516</del>	<del>WASHER</del>
8	<del>(8)</del>	8	8	MS21042L4	NUT (or MS21042-4)
2	<del>(2)</del>	2	2	<del>MS21042L5</del>	<del>NUT (or MS21042-5)</del>

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Revision: B

Date: 07.08.21